

CLAIMS

1. A method of building a folded breaker for a tire building drum having a plurality of drum folding modules at spaced apart edge positions circumferentially of said drum with each module having a belt with a first belt end fastened to said module and a second belt end fastened to an axially movable nose member comprising:
 - a. wrapping a wide breaker ply around said drum and said first belt end of each said belt fastened to said module and splicing a leading end edge and a trailing end of said wide breaker ply together,
 - 10 b. wrapping a narrow breaker ply having a width less than the width of said wide breaker ply around said wide breaker ply exposing an overlap edge of said wide breaker ply at each edge of said wide breaker ply and splicing a leading end and a trailing end of said narrow breaker ply, together and,
 - c. folding each said overlap edge of said wide breaker ply over each side edge of said narrow breaker ply by moving said belt carrying each said overlap edge over each said side edge of said narrow breaker ply and by moving each said nose member axially inward over each said side edge of said narrow breaker ply.
2. The method of claim 1 further characterized by moving each said nose member radially outward for carrying said belt and said overlap edge of said wide breaker ply over each said side edge of said narrow breaker ply.
3. The method of claim 2 further characterized by maintaining each said overlap edge of said wide breaker ply in contact with said belt during said application over each said side edge of said narrow breaker ply by maintaining said belt in tension.
4. The method of claim 1 further characterized by peeling said belt away from each said overlap edge after folding each said overlap edge over each said side edge of said narrow breaker ply by moving each said nose member axially outward relative to said module.